

Work Order ID 155037

Thursday, January 05, 2017 11:51:06 AM

155037

Page 1

Item ID: D350-689-017 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Shoulder Harness 4 Point Inertia Reel
 Start Date: 1/18/2017 Start Qty: 2.00 *P*3 DAS 21 9-89 Cust Item ID:
 Required Date: 1/30/2017 Req'd Qty: 2.00 *J* Customer:
 Reference:

Approvals: Process Plan: DAS 21 9-89 Date: JAN 06 2017 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile and create labels per PPP D350-689-017 CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.01							
Quality Control									

24 per

FEB 03 2017

3x

3

3x

1702-03/3

DAS 6 27 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Work Order ID 155037***155037***

Page 2

Thursday, January 05, 2017 11:51:06 AM

Item ID: D350-689-017

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Shoulder Harness 4 Point Inertia Reel

Start Date: 1/18/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 1/30/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130						3X	DAS 28 9-89	DAS 27 9-89	FEB 06 2017
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-689-017 Location: FG029								
140	QC21- Final Inspection - Work Order Release	0.00							
140							DAS 21 9-89		FEB 06 2017
QC	Memo	0.03							
Quality Control									
							DAS 21 9-89		FEB 06 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : _____							

Picklist Print

Thursday, January 05, 2017 11:51:05 AM

Page 1

Work Order ID: 155037

155037

Parent Item: D350-689-017

D350-689-017

Parent Item Name: Shoulder Harness 4 Point Inertia Reel

Start Date: 1/18/2017

Required Date: 1/30/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A new issue DD 10.04.23 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN5-4A *AN5-4A* Bolt		Purchased	No			110	Each	21.0000	2 **	4 6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST339				21					
				M133932				21					
D4071-041 *D4071-041* Shoulder Harness Assembly		Manufactured	No			110	Each	6.0000	2 **	4 6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST464				6					
				152289				2					
				153022				4					
MS21042L5 *MS21042L5* Nut		Purchased	No			110	Each	421.0000	2 **	4 6			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				21					
				m127813				21					
				OVER007				100					
				m136450				100					
				ST303				300					
				m135774				4					
				m136047				196					
				m136295				100					

FEB 03 2017

FEB 03 2017

FEB 03 2017

DAS
6
9-89

DAS
28
9-89

DAS
6
9-89

DAS
28
9-89

DAS
28
9-89

DAS
6
9-89

DAS
28
9-89

DAS
28
9-89

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Page 2

Thursday, January 05, 2017 11:51:06 AM

Work Order ID: 155037

155037

Parent Item: D350-689-017

D350-689-017

Parent Item Name: Shoulder Harness 4 Point Inertia Reel

Start Date: 1/18/2017

Required Date: 1/30/2017

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0516J

Purchased

No

110

Each

123.0000

NAS1149D0516.J

Washer

**

8 12

DAS FEB 03 2017

Location

Loc Qty

Loc Code

ST264

123

M134943

123

12

DAS
28
9-89

Thursday, January 05, 2017 11:51:06 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

Work Order ID 155037***155037***

Page 1

Friday, February 03, 2017 10:33:57 AM

Item ID: D350-689-017

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Shoulder Harness 4 Point Inertia Reel

Start Date: 1/18/2017 Start Qty: 3.00

3

Cust Item ID:

Required Date: 1/30/2017 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D350-689	C

DAS
21
9-89

FEB 03 2017

100	Document Control	0.00							
-----	------------------	------	--	--	--	--	--	--	--

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D350-689-017 CHG001

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

QC4- 100% Inspect kits for completeness

0.00

20

Memo

0.02

Quality Control

6.0 PARTS LIST (OPTIONAL KITS)

Qty -015	Qty -017	Qty -031	Part Number	Description
X			D350-689-015	SEAT MODIFICATION KIT
	X		D350-689-017	SHOULDER HARNESS KIT
		X	D350-689-031	ARMREST KIT
		1	D2199-31	STRUT
2			D3029-1	SPRING
2			D3030-1	LOCK
1			D3033-1	SEAT TRACK
4			D3059-1	STUD
4			D3060-1	BUSHING
4			D3061-1	RADIUS BLOCK
	2		D4071-041	SHOULDER HARNESS ASSY
		1	D4671-1	ARMREST CUSHION
		1	D5159-041	SEAT BACK BRACE ASSY
		1	D5159-043	SEAT BACK BRACE ASSY
		1	D5159-045	SEAT RIB ASSY
		1	D5189-041	TUBE ASSY
		1	D5189-043	ARMEST ASSY
			AN3-12A	BOLT
		1	AN4-4A	BOLT
		1	AN4-6A	BOLT
		1	AN4-10A	BOLT
		2	AN4-14A	BOLT
		1	AN4-17A	BOLT
	2		AN5-4A	BOLT
		1	AN970-4	WASHER
		4	MS20600AD4W4	BLIND RIVET
		8	MS20600AD4W5	BLIND RIVET
		10	MS21042L3	NUT (OR MS21042-3)
		8	MS21042L4	NUT (OR MS21042-4)
4	2		MS21042L5	NUT (OR MS21042-5)
4			MS21059L3	NUTPLATE
1			MS24693-S273	SCREW
3			MS27039-1-10	SCREW
		1	MS27039-1-17	SCREW
		3	MS27039-1-18	SCREW
		4	MS27039-1-19	SCREW
		2	MS27039-1-20	SCREW
		4	MS27039-4-20	SCREW
		2	MS27039-4-22	SCREW
		4	MS27039-4-21	SCREW
		20	NAS1149D0332J	WASHER (OR AN960JD10L)
		17	NAS1149D0432J	WASHER (OR AN960JD416)
	4		NAS1149D0516J	WASHER (OR AN960JD516L)
4			NAS1149D0563J	WASHER (OR AN960JD516)
		2	NAS43DD4-16FC	SPACER